

इंटरनेट

मानक

Disclosure to Promote the Right To Information

Whereas the Parliament of India has set out to provide a practical regime of right to information for citizens to secure access to information under the control of public authorities, in order to promote transparency and accountability in the working of every public authority, and whereas the attached publication of the Bureau of Indian Standards is of particular interest to the public, particularly disadvantaged communities and those engaged in the pursuit of education and knowledge, the attached public safety standard is made available to promote the timely dissemination of this information in an accurate manner to the public.

“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 11127 (1984): Holders for Knurling Wheels [PGD 32: Cutting tools]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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Indian Standard

SPECIFICATION FOR HOLDERS FOR KNURLING WHEELS

1. Scope — Covers the dimensions and requirements of three types of holders for knurling wheels.

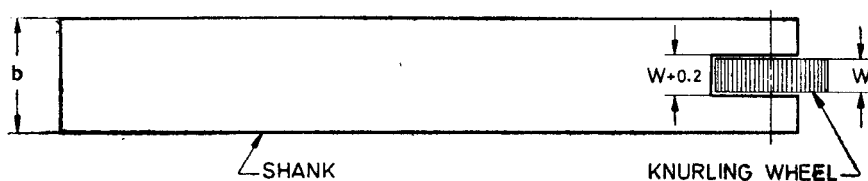
2. Types

Type A — Single wheel holder.

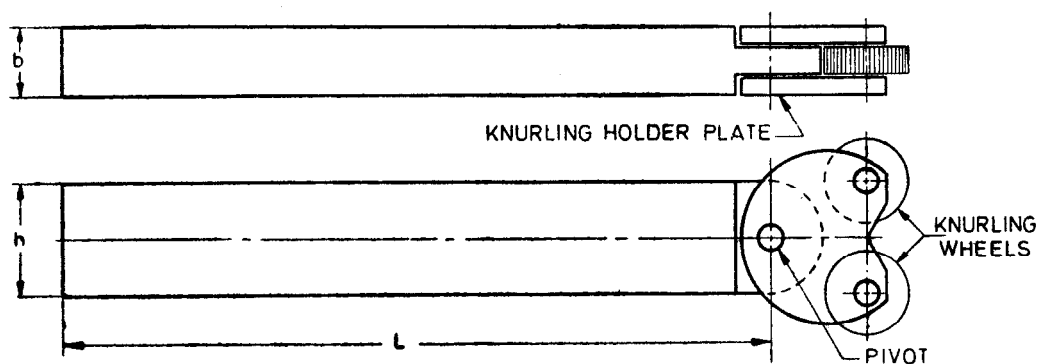
Type B — Two wheel holders with pivoted head, self adjusting to the work.

Type C — Holder for three pairs of wheels (fine, medium and coarse pitch) with positive locking device.

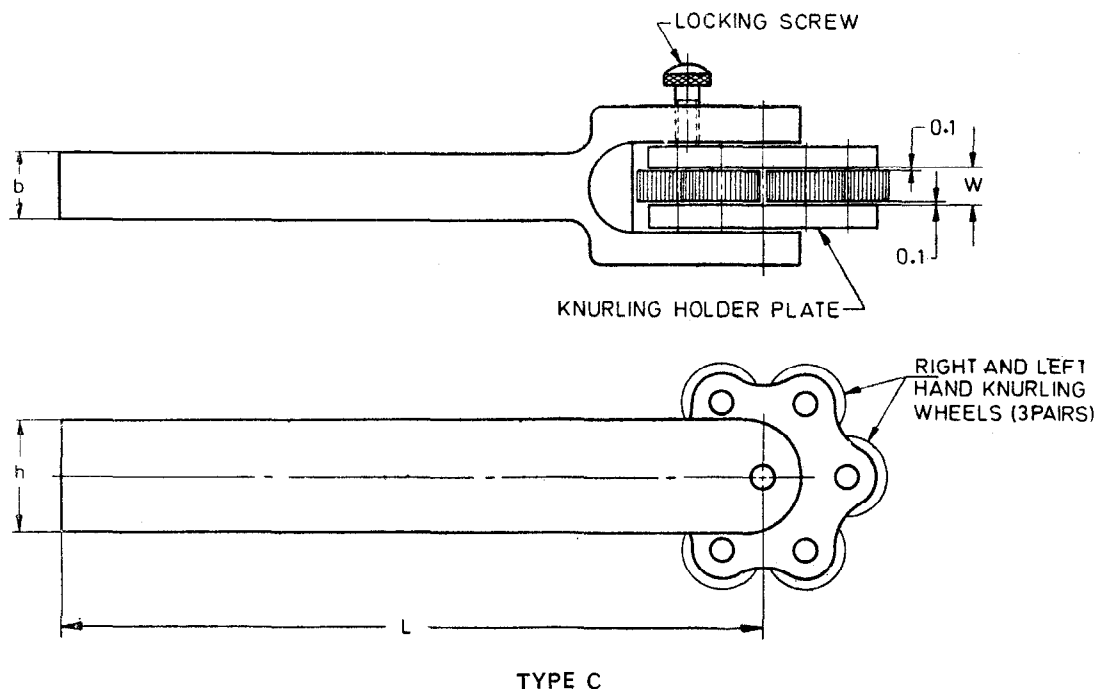
3. Dimensions



TYPE A



TYPE B



All dimensions in millimetres.

Type	Shank $h \times b$	Knurling wheel					
		L	Dia	Width (W)	Bore	Pitch	Type
A	16 × 16	115	Shall be according to IS : 6776-1980 'Specification for knurling wheels (first revision)'.				
	20 × 20	125					
	25 × 25	165					
B	16 × 10	115					
	20 × 12	125					
	25 × 20	165					
C	20 × 12	125					
	25 × 25	165					

Note — Only shank section and length are given. Other details of design are left to the manufacturer's discretion.

4. Knurling Wheels — Shall be according to IS : 6776-1980.

5. Material — The material for the shank of the knurl holder shall be steel having a tensile strength not less than 700 MPa.

6. Hardness — The bearing portion of wheel pin shall be case hardened to 600 to 700 HV.

7. General Requirements — The knurling wheel shall rotate freely over the wheel pin (G 7/h7 fit). The ends of wheel pin shall be press fit.

8. Designation — A knurling wheel holder of Type A having shank section 16 × 16 and length 115 mm with knurl size 20 (dia) × 6 (width) × 6 (bore) with pitch 1.0 and type of knurling wheel AA and conforming to this standard shall be designated as:

Knurl Holder A 16 × 16 × 115 20 × 6 × 6 × 1.0 AA IS:

9. Workmanship and Finish — The holder shall be free from burrs, cracks and sharp edges. All surfaces shall be smooth.

10. Surface Protection — The screws, holding plate and shank shall be blackened or blued to prevent rust.

11. Marking — Shall be marked with the type, shank Size and the manufacturer's name or trade-mark.

11.1 ISI Certification Marking — Details available with the Indian Standards Institution.

12. Packing — The holders shall be covered with grease or rust proofing material and wrapped in non-absorbent paper. Each piece or a number of pieces shall be packed in cartons bearing the manufacturer's name or trade-mark.

EXPLANATORY NOTE

This standard is formulated based on the current practices prevalent in the industry.